



DIN 8555 WSG 3-GZ-55T  
 Werkstoffe No. 1.2343  
 UNS T 20811

# TIG Filler Wire

## Hot work Tool Steel (H11)

**HW-1461**

### DESCRIPTION & APPLICATION

TIG Filler Wire for the repair and reclamation of Hot Work Tool Steels, Cropping and Cutting Blades, Hot Shear Blades and surfacing on machine components and tools. Particularly suitable for those exposed to temperatures up to 500°C, together with abrasion, compression and erosion. Matching filler for H11.  
 Usage includes cutting edges for guillotine blades, dies, swages and hammers

### BASE MATERIALS

BS D3, S1, 2767, W2, H13, H10, H11, O1  
 Werkstoffe Nr. 1.2080, 1.2550, 1.2767, 1.2833, 1.2343, 1.2344

### MECHANICAL PROPERTIES

N/A	N/A	N/A	~550-600
UTS n/mm	YIELD 0.2%	ELONG A5%	HARDNESS HV

### METAL WELD COMPOSITION %

<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Cr</b>	<b>V</b>	<b>Mo</b>
0.40	1.0	0.40	5.0	0.4	1.1

### PACKAGING

5kg Tubes (TIG)

### DIAMETERS

1.6, 2.4, 3.2mm (TIG)

### WELDING INSTRUCTIONS

Always preheat as per the requirements of the base material. Large deposits will require a buffer layer of SW 312 or NW 1720 to avoid cracking.

**For more details on welding of Tools and Dies, please see our Information Sheets.**  
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